

Work Order ID 67665-1

Tuesday, March 29, 2011 9:25:08 AM



Page 1

Item ID: D2573

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft Out 205

Start Date: 3/30/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 11-03-29

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2573

Rev E

0.00

100



HAAS CNC VERTICAL MACHINING #1

BA 11/04/06

6 0

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 67665 Double check by: ZP 11-Machine Step No  
1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step  
No 2 per Folio FA051 and inspect per attached Dimension Sheets 13-Machine  
Step No 3 per Folio FA051 and insp

0.00

110



CONVENTIONAL MILLING MACHINE

BA 11/04/06

6 0

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

0.00

120



QC2- Inspect parts off machine FA1/FA1B

BA 11/04/06

6 0

QC

Memo

0.00

Quality Control

ZP 11.5.10

# Work Order ID 67665



Page 2

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*11/05/11*



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



Hand Finish

Memo

0.00

Hand Finishing

*6x 11/05/11*

150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

FINISH TIME:

OVEN TEMPERATURE.

*3:10*  
*3:20*

*3:40*

*6x 11/05/12*

# Work Order ID 67665

Tuesday, March 29, 2011 9:25:08 AM



Page 3

Item ID: D2573

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft Out 205

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Gx 0 11/05/13

170

Identify as per dwg & Stock Location:

434

0.00



Packaging

Memo

0.00

Packaging

11/05/12 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10

MF

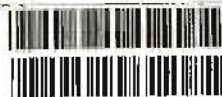
11-05-13

# Picklist Print

Page 1

Tuesday, March 29, 2011 9:25:06 AM

Work Order ID: 67665



Parent Item: D2573

Parent Item Name: Saddle, Alt Out 205

Start Date: 3/30/2011

Required Date: 4/13/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	53.0000	1	12			



Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT042	20	
66967	20	
MAT045	33	
65383	13	
65954	20	

9
5

4 11/04/05



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	67665
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443						Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	CNC-07
F	0.490	0.510		.507	.503	.508	.503	Vern	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		0.501	.500	.500	.500	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.568	.566	.566	.566	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.365	1.375		1.370	1.370	1.370	1.370	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	4.119	4.129		4.124	4.124	4.124	4.124	"	"
P	0.115	0.135		.128	.127	.127	.129	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		.257	.258	.255	.258	"	"
S	0.115	0.135		.123	.120	.123	.123	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	3.210	3.250		3.230	3.230	3.230	3.230	Vern	GA-01
V	0.230	0.250		.245	.245	.245	.245	"	"
W	0.115	0.135		.125	.122	.122	.122	Mic	118-120
X	0.308	0.313		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.764	0.764	0.764	0.764	"	"
Z	0.352	0.372		.364	.364	.364	.364	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		.627	.627	.627	.627	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		.250	.250	.250	.250	Vern	GA-01
AE	1.500	1.520		1.514	1.513	1.511	1.512	H-6	31006
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		.248	.248	.248	.248	"	"
AH	0.240	0.260		.253	.253	.253	.253	"	"
AI	2.000	2.020		2.004	2.003	2.002	2.002	H-6	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	H-6	31006
Accept/Reject								Vern	GA-01

Measured by:	H.A. / Rq
Date:	11/04/06

Audited by:	SL
Date:	11/05/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 67665
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443						Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000			Vern	CNC-02
F	0.490	0.510		.497	.497			Vern	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		.500	.502			"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		.566	.568			"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.365	1.375		1.370	1.370	1.370	1.370	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	4.119	4.129		4.124	4.124	4.124	4.124	"	"
P	0.115	0.135		.126	.128			Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		.252	.256			"	"
S	0.115	0.135		.123	.122			Mic	11B-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	3.210	3.250		3.230	3.230	3.230	3.230	Vern	GA-01
V	0.230	0.250		.245	.240			"	"
W	0.115	0.135		.122	.126			Mic	11B-120
X	0.308	0.313		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.764	0.764	0.764	0.764	"	"
Z	0.352	0.372		.364	.364	.364	.364	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		.627	.627			Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		.257	.257			Vern	GA-01
AE	1.500	1.520		1.512	1.512			H-6	31006
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		.248	.248	.248	.248	"	"
AH	0.240	0.260		.255	.255			"	"
AI	2.000	2.020		2.002	2.002			H-6	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

Measured by: RF
Date: 11.5.11

Audited by: SL
Date: 11.6.11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

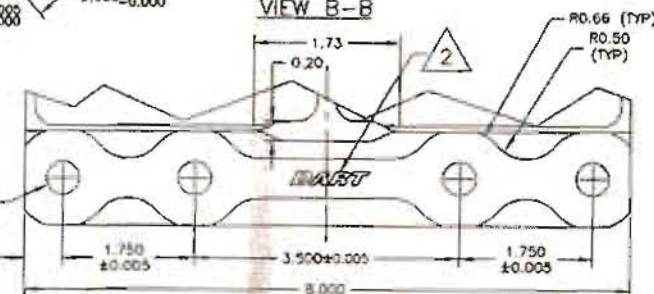
05-10-16

# NOTES

MATERIAL: 7075-T7351 (Q0-A-750/12)  
(REF DART SPEC D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK: ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

## VIEW B-B

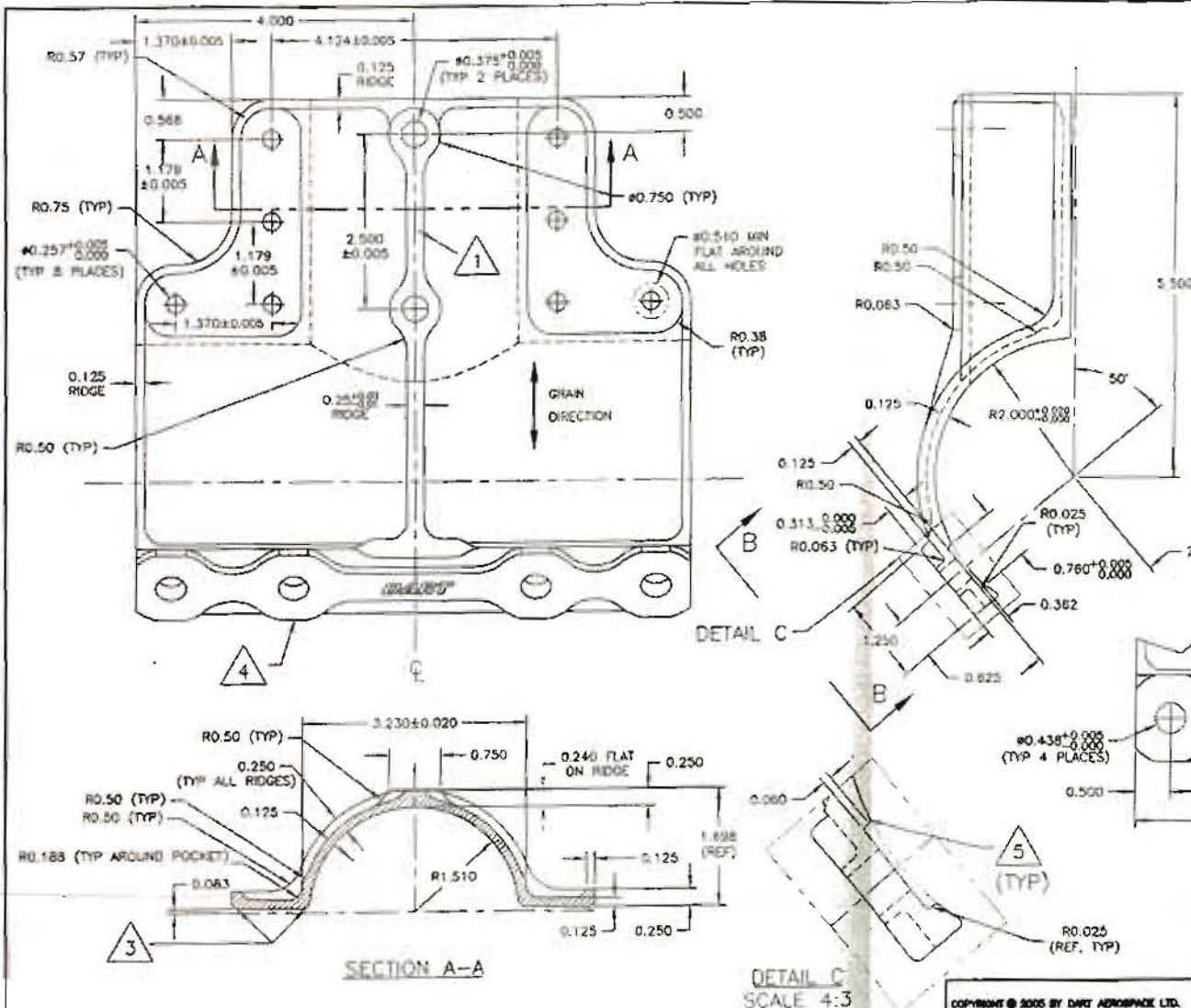


E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES, TIGHTEN TOLERANCES
C	09.10.22	INCCORP DEC 9123/9079/9102 --ADD DIMENSIONS PER TSR A1177
B	06.12.02	ADD GRAIN DIR. 0.438 WAS 0.425
A	68.09.16	NEW ISSUE

DESIGN	DS	DESIGN BY	PH	<b>DART</b>	DART AEROSPACE LTD.
CHECKED	PH	APPROVED	PH	DART	WINDSOR, ONTARIO, CANADA
DATE	05.07.13	DRAWING NO.	D2573	REV B	SHEET 1 OF 1
		TITLE	OUTER AFT SADDLE	SCALE	2:1

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## SECTION A-A

DETAIL C  
SCALE 4:3